

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012827**Date Inspected:** 21-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:			

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port

Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This inspector witnessed the following work in progress:

Flux Cored Arc Welding (FCAW) of 20TR1-032; Weld 003. Welder is identified as 219188. ZPMC Quality Control (QC) was identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-027; Weld 007. Welder is identified as 250672. ZPMC Quality Control (QC) was identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-035; Weld 003. Welder is identified as 215397. ZPMC Quality Control (QC) was identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-040; Weld 011. Welder is identified as 059450. ZPMC Quality Control (QC) was identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-034; Weld 013. Welder is identified as 216872. ZPMC Quality Control (QC) was identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Heat Straightening was observed pursuant to HSR1 (B)- 8160 on traveler rails 10TR1-004 and 11TR1-026. All variables of the HSR appeared to be in general compliance.

Flame cutting of weld preps to various floor beam plates for the lift 13 mock ups was observed.

Repair welding of 11TR3-003 pursuant to B- CWR 1100. The welder was identified as 048625. The welding procedure was identified as WPS-345-FCAW-1G (1F)-Repair-1. All work appeared to comply with the WPS and the contract documents.

Repair welding of 11TR8-002-014 pursuant to B- CWR 11010. The welder was identified as 054460. The welding procedure was identified as WPS-345-FCAW-1G (1F)-Repair-1. All work appeared to comply with the WPS and the contract documents.

This inspector witnessed conventional ultrasonic inspections, UT, by ZPMC personnel on 21TR4-002. Indications were noted at the time of inspection and were documented by ZPMC. Areas for repair were marked directly on the weld.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
